

Work Order ID 77163***77163***

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November-28-11 8:59:03 AM

Item ID: D3017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Back Frame Assembly
Start Date: 28/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/12/2011 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: M.L.S Date: 11/11/28 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3017	Rev B								

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00
100 Large Fab
Memo 0.00
1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
3-Drill holes in D3017-5 Using DT8622
4-Deburr
5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
6-Drill holes in back frame using DT8621

0 02 12-5-17

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00
Quality Control

11 12.05.17

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120		0.00							
QC	Memo								
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130		0.00							
Powdercoat	Memo								
Powder Coating	START TIME: 8:00 OVEN TEMPERATURE: 3200F FINISH TIME: 8:30								
140	QC3- Inspect Part Finish	0.00							
140		0.00							
QC	Memo								
Quality Control									

M117338

MA
12/05/22

1 0 BL12522

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>6A</u>	0.00							
150									
Packaging	Memo <u>B77161</u>	0.00				<u>1X</u>			<u>12/15/23</u>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<u>12/15/25</u>
Quality Control									<u>MF</u> <u>12-05-23</u>

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Picklist Print

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Page 1

Work Order ID: 77163

77163

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.083

Purchased

No

100

f

48.2470

2.458

2.587368

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

EL 12-5-11

Location

Loc Qty

Loc Code

MAT033

48.247

117579

24.33

117973

23.917

2.58

M4130NT0.750W.049

Purchased

No

100

f

69.8000

11.125

11.71053

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

EL 12-5-17

Location

Loc Qty

Loc Code

MAT033

69.8

118772

69.8

12.04.

D3017-11

Manufactured

No

100

Each

64.0000

2

2

D3017-11

cap

**

EL 12-5-17

Location

Loc Qty

Loc Code

WA

64

69074

2

76851

62

2

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Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3017-7

Manufactured No

100

Each

19.0000

3

3

D3017-7

**

Q 12-5-15

Lug

Location

Loc Qty

Loc Code

WA

9

69166

1

70905

8

WA019

1

52915

1

WA030

9

70871

9

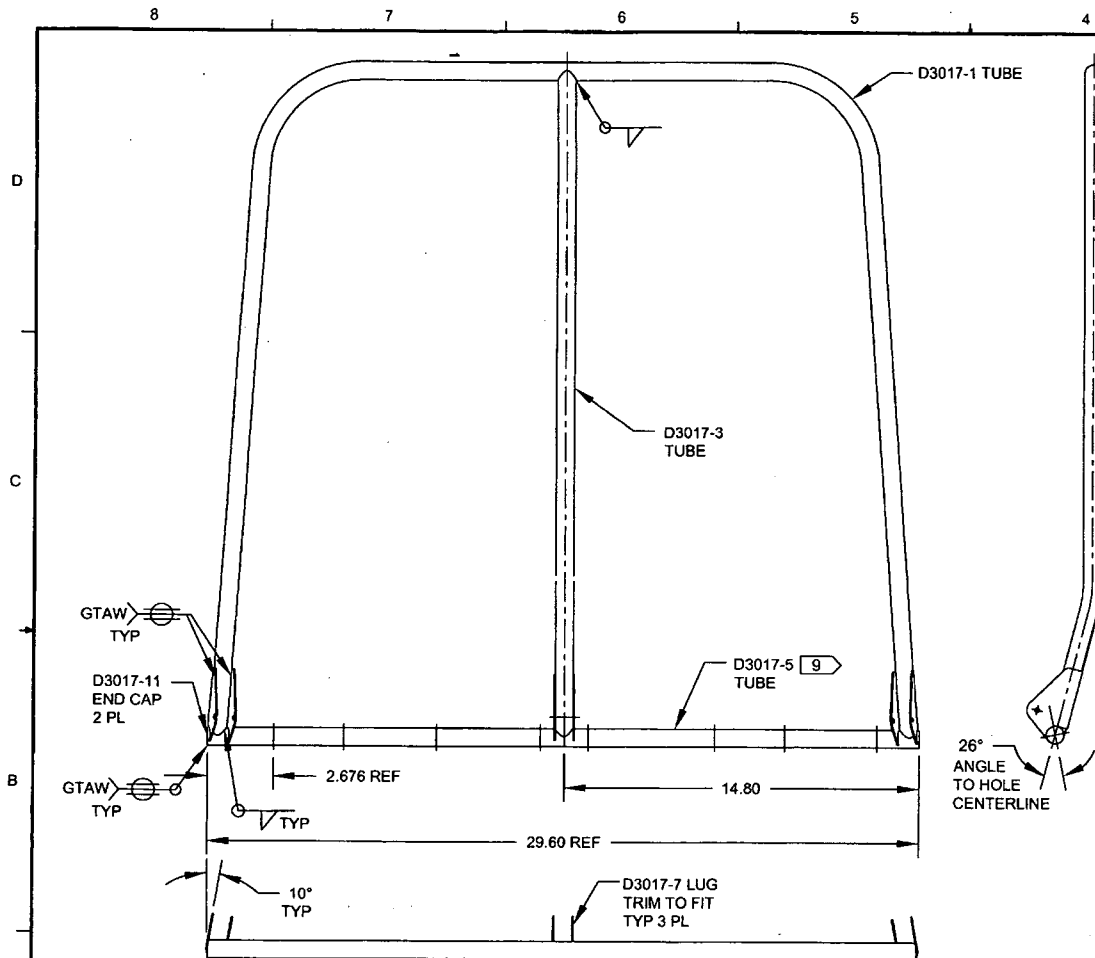
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ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 77163 M.L.J

11/11/28 RELEASED
2010-02-02
WJP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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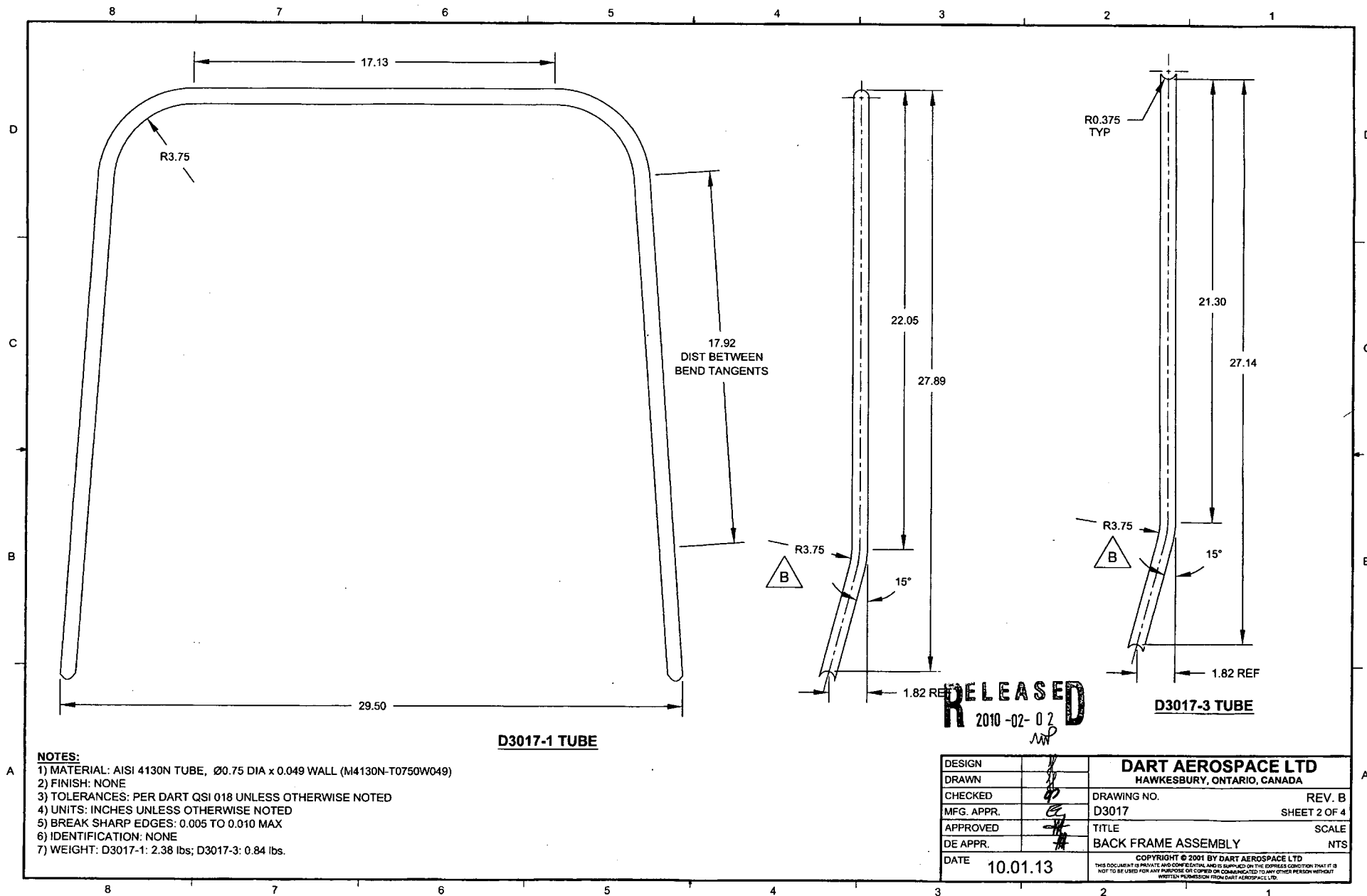
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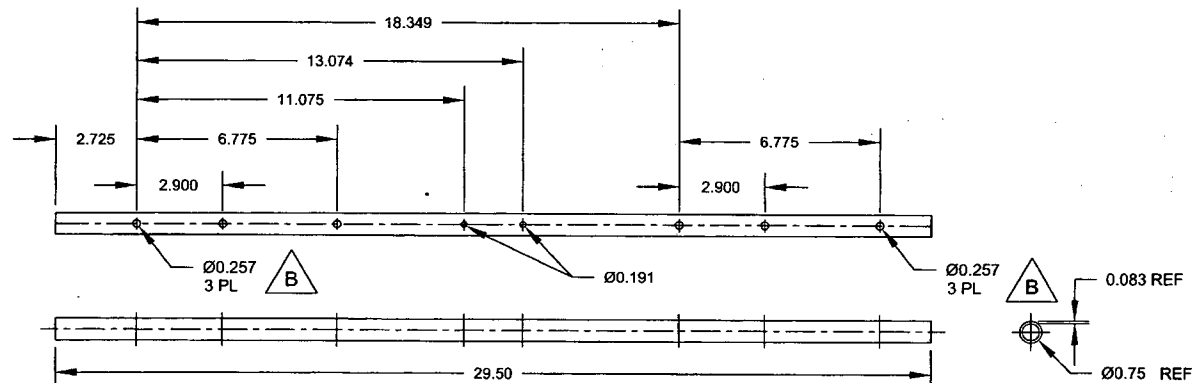
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77163



D3017-5 TUBE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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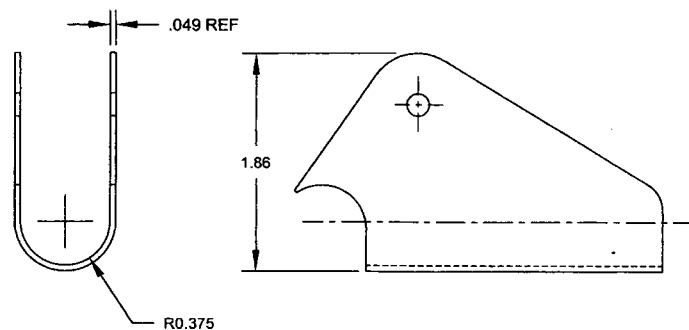
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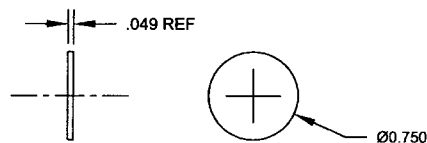
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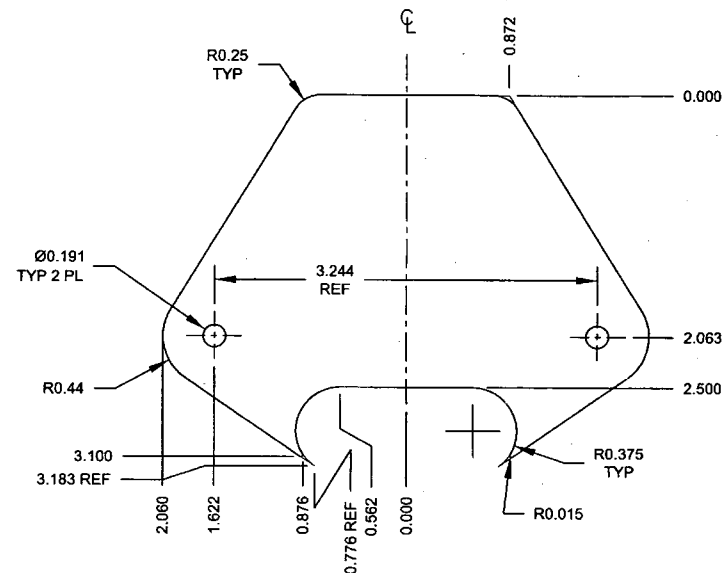
77163



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

RELEASED
2010-02-02

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
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